

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016176**Date Inspected:** 05-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Geng wei / Li yan hua / Xu tao	CWI Present:	Yes	No	
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes No N/A	Approved WPS:	Yes	No	N/A
		Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG Components		

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

SAW welding of weld joint 1G-004 located on PCMK SEG3014A for Segment 13BW the welder is identified as 045270. ZPMC QC is identified as Mr. Wang xu. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2c-S-2.

SMAW welding of weld joint 3F-090 located on PCMK SEG3005C for Segment 12BW the welder is identified as 045133. ZPMC QC is identified as Mr. Wang wei ming. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2113.

BAY#19

FCAW welding of weld joint 2G-025 located on PCMK SB019-076 for OBG SB76E the welder is identified as 062806. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint 2G-001 located on PCMK SB016-072 for OBG SB72W the welder is identified as 062761. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

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FCAW welding of weld joint 2G-005 located on PCMK SB020-084 for OBG SB84E the welder is identified as 062783. ZPMC QC is identified as Mr.Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint 2F-077 located on PCMK SB019-080 for OBG SB80E the welder is identified as 062794. ZPMC QC is identified as Mr.Xu tao. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

This QA inspector performed 15% MT of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as Side panel for OBG Suspender bracket. The weld designations reviewed as follows.
SB018-094-002,003,029,027,024,021,039,040,045,052,053,064,066,060,058. Green tag-12281.

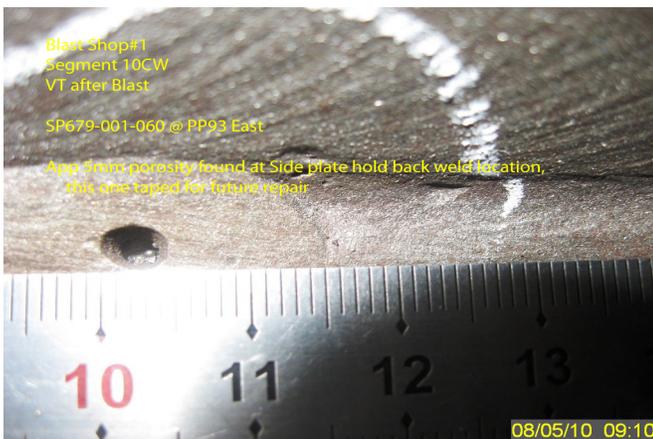
BLAST SHOP#1

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG segment 10CW Internal Bottom panel, Side panel, longitudinal diaphragm and Corner assembly from the panel point 92 to 94 after grit blasting. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

SP679-001-060, 5mm Porosity found, marked for future repair and informed to ABF QA Mr. Kasi wang.

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG segment 10CE External Bottom panel, Side panel, Deck panel from the panel point 92 to 94 after grit blasting. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

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No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
